

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 132591

132591

Page 2

Item ID: D2894-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 2.75 Support

Stop

NS2

Start Date: 5/07/15

Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/07/15

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

LOCATION: LG052

DAS
41
9-89

15-5-26

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MUS MAY 27 2015

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

May-07-15 2:59:52 PM

Page 1

Work Order ID: 132591

132591

Parent Item: D2894-1

D2894-1

Parent Item Name: 2.75 Support

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B02.11.26Added mask holeKJ
IPP Rev:C ECN 993 07-11-07 DD verified by:EC
IPP D 08.03.19 Re-format EC verified by DD IPP REV:E
11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK079		Manufactured	No			100	Each	5.0000	0.5	3			
DSK079									**				
D2894-1 Turning Detail													

DAS
44
9-89

15/05/20

Location

Loc Qty

Loc Code

MAT060

5

126547

5

3

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

DART AEROSPACE LTD		Work Order:	132591
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.460	.460	.460	.460	.461
AB	3.062	3.082		3.074	3.074	3.074	3.074	3.074
AC	0.053	0.073		.063	.063	.063	.063	.063
AD	1.766	1.786		1.768	1.768	1.776	1.766	1.776
AE	0.020	0.040		.030	.030	.030	.030	.030
AF	0.260	0.267		.261	.261	.261	.261	.261
AG	0.170	0.190		.175	.175	.175	.175	.175
AH	0.150	0.170		.155	.155	.155	.155	.155
AI	1.970	2.030		2.000	1.999	2.000	2.000	2.001
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	1.880	1.900		1.890	1.890	1.890	1.890	1.890
AL	0.500	0.505		.502	.502	.502	.502	.502
AM	0.188	0.194		.189	.189	.189	.189	.189

Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"

Accept/Reject	.0005	.0005	.0015	.0015	.001
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Measured by:	DAS 20	Date:	15-08-22
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Audited by:	9-89 DAS 08	Date:	15/05/26
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Preliminary Approval:		Date:	
------------------------------	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	

DART AEROSPACE LTD		Work Order: 132591
Description: Ø2.750 Support		Part Number: D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1

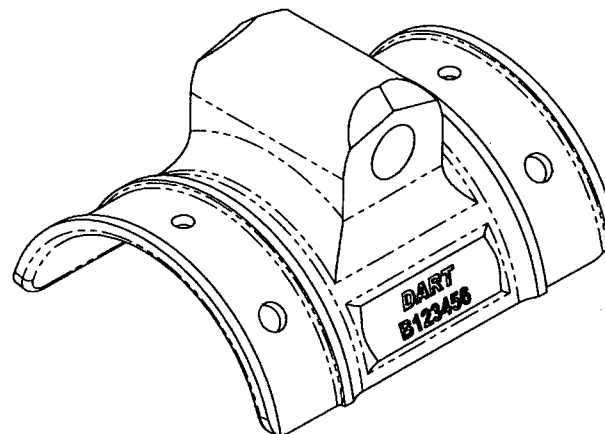
FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.461				
AB	3.062	3.082		3.074				
AC	0.053	0.073		.063				
AD	1.766	1.786		1.776				
AE	0.020	0.040		.030				
AF	0.260	0.267		.261				
AG	0.170	0.190		.175				
AH	0.150	0.170		.155				
AI	1.970	2.030		2.002				
AJ	0.240	0.260		.250				
AK	1.880	1.900		1.890				
AL	0.500	0.505		.502				
AM	0.188	0.194		.189				
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				.0015				

DAS

Measured by:	20	Date:	15-05-26
	9-89		
Audited by:	A.P.	Date:	15/05/26
	08		
	9-89		
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
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F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	



D2894-1 Ø2.750 SUPPORT

STOP COPY

RETURN TO

DATE

COPY

DATE

DATE

DATE

132591 MLJ

15-05-08

RELEASED
2011-09-29

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRC)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,

WITH R0.25 RADIUS OF TRANSITION IN THIS AREA

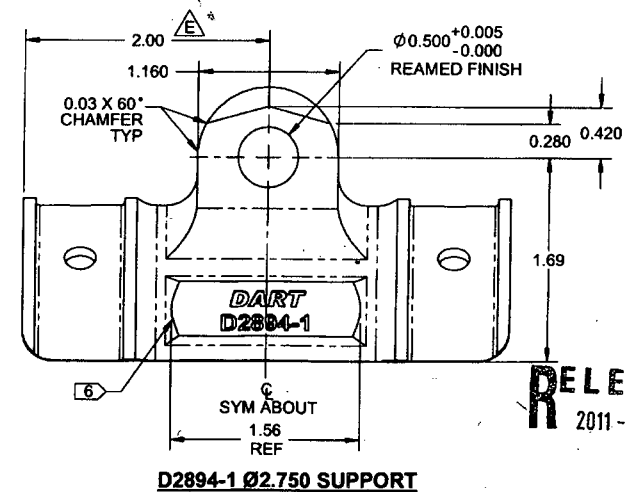
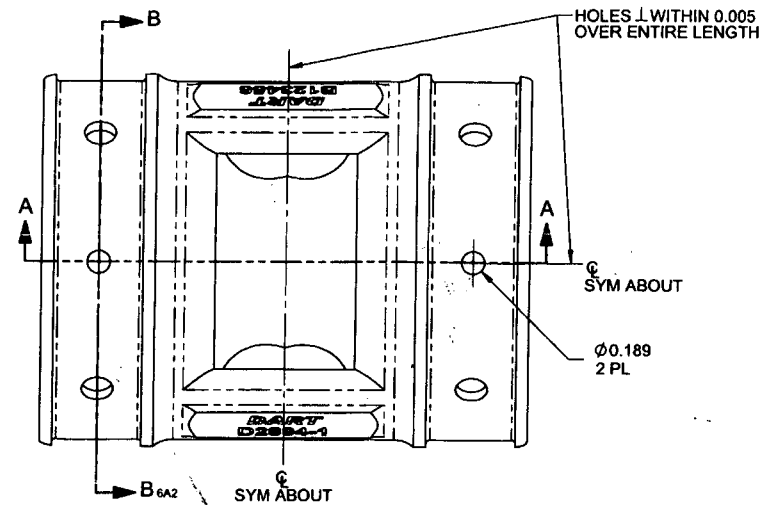
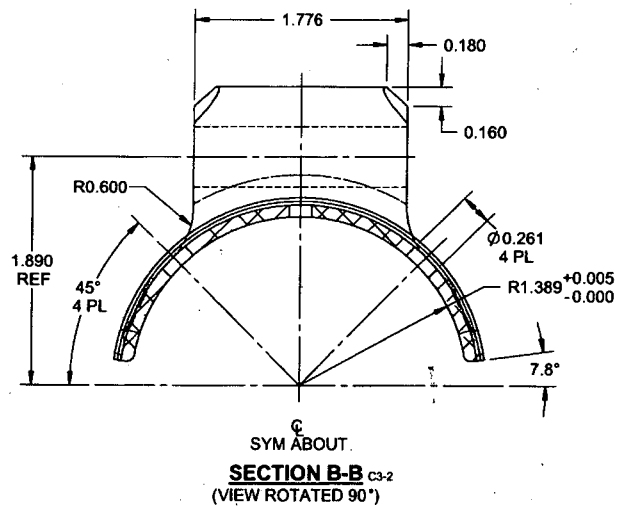
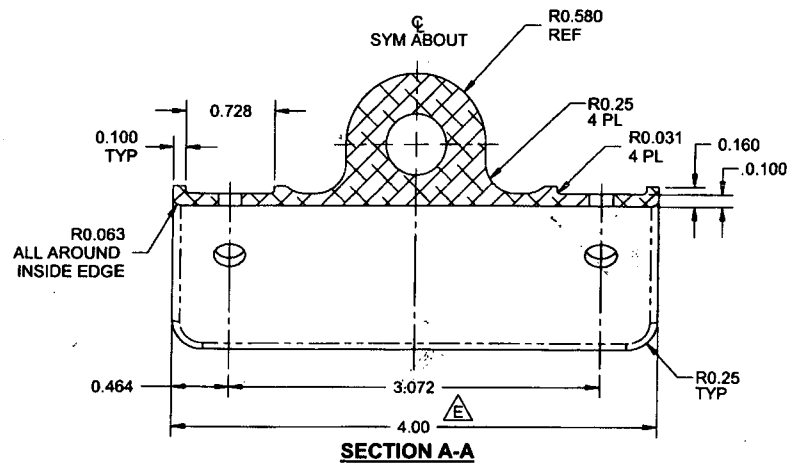
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE

SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE

SIDE USING 0.010-0.020 DEEP LETTERING

7) WEIGHT: 0.98 lbs

E	REMOVE PRIMER & UPDATE MAT'L SPEC (ZN A8-1), 2.00 WAS 2.000 (C3-2), 4.00 WAS 4.000 (C6-2), REF. CAR 11-51	CP	11.09.07
D	DRAWING REFORMATTED, POWDER COAT FINISH REMOVED, CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84, B5-2 0.261 HOLE WAS 0.257, B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2894	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	Ø2.750 SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
2011-09-29

D2894-1 Ø2.750 SUPPORT

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2894	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	Ø2.750 SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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